

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023924**Date Inspected:** 22-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

CWI Inspector: N/A

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. This QA Inspector observed the following:

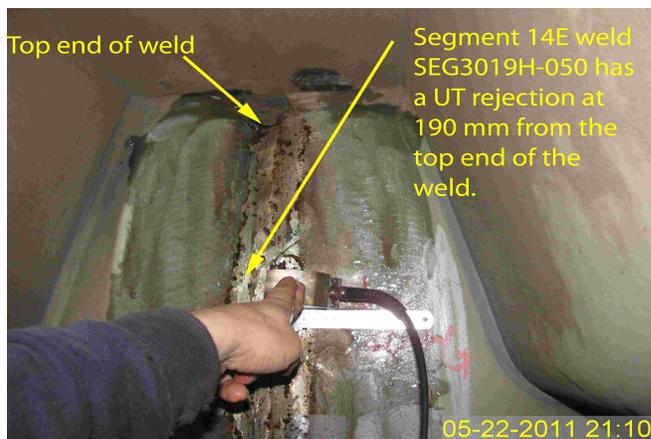
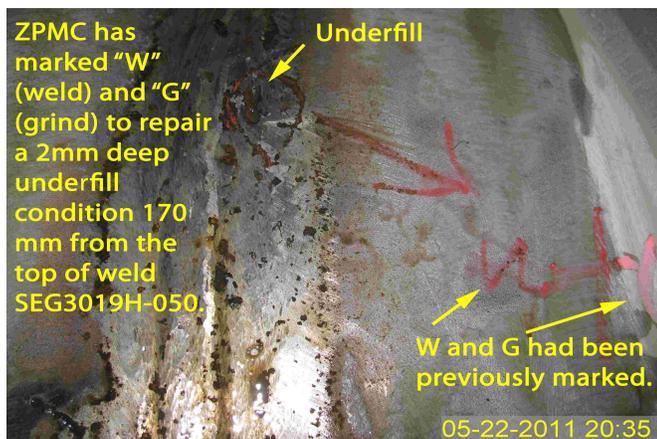
OBG Trial Assembly

ZPMC issued "Inspection Notification Sheet" number 09217 item #1 informing Caltrans QA that ZPMC is requesting ultrasonic inspections (UT) of OBG segment 14E complete joint penetration welds. This tracker lists approximately two hundred welds. This QA Inspector performed random visual and ultrasonic inspections of the following welds: SEG3019AE-005~007, 012~014, 019~021, 026~028, 033~035, 040~042, 047~049, 054~056, 061~063, 072~074, 123, 126, 129, SEG3019AF-005~007, 012~014, 019~021, 026~028, 033~035, 040~042, 047~049, 072~074, 087~090, SEG3019H-050 and SEG3019B-049. All welds listed above except for weld SEG3019H-050 appear to comply with project specifications. This QA Inspector visually observed weld SEG3019H-050 appears to have a 2mm deep underfill in the face of the weld located approximately 170 mm from the top end of the weld. This area had been previously marked by an unknown person as needing to be welded and ground. This QA Inspector observed a class "A" (2DB) ultrasonic indication located at approximately 190 mm from the top end of the weld. This QA Inspector informed ABF representative Mr. Tao Lin Ying and ZPMC QC Inspector Mr. Sun Tian Liang that an incident report will be issued due to the visual and ultrasonic rejections. For

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additional information on these inspections see this QA Inspector's TL6027 Ultrasonic Test Report and the photographs below.



Summary of Conversations:

See Above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey +8615000026784, who represents the Office of Structural Materials for your project.

Inspected By: Dawson,Paul

Quality Assurance Inspector

Reviewed By: Riley,Ken

QA Reviewer
